

Work Order ID 73082

Thursday, August 25, 2011 1:34:15 PM



Page 1

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Item Name: Fuel Purge Canister

Stop



Start Date: 8/25/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 3.00



Customer:

Ship sept 01

Reference:

Approvals: Process Plan: *MF*

Date: *11-08-25* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9494	A
IIN-D412-706	A

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

8/26/08

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

11/8/30 sl30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73082

Thursday, August 25, 2011 1:34:15 PM



Page 2

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 8/25/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 ulozlog

73

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD412-706-011

Location: _____

PPP Rev: E

11/9/8

SD 30

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/8

MF 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 1:34:11 PM

Page 1

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister



Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM
REV: IPP
IPP Rev:F 08-05-14 revise comment in seq.17/24 DD verified by:EC IPP rev G
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23 as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per chg003 DD verified :EC IPP REV K 11.06.17 AS PER CHG
002 JLM VERIFIED BY:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2001-4 Valve Assembly (1/4")		Manufactured	No			110	Each	1.0000	1	3	22	73083	
				<u>Location</u>				<u>Loc Qty</u>					
				ST002				1					
				68025				1					
D3262-043 Canister Assembly		Manufactured	No			110	Each	0.0000	1	3	34	1373084	
D3264-1 Bracket		Manufactured	No			110	Each	6.0000	2	6		11/1/18	
				<u>Location</u>				<u>Loc Qty</u>					
				ST144				6					
				70614				6					
D3297-1-0098 HOSE ASS'Y		Manufactured	No			110	Each	3.0000	1	3	3	73086	
				<u>Location</u>				<u>Loc Qty</u>					
				ST194				3					
				70218				3					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Thursday, August 25, 2011 1:34:11 PM

Page 2

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

D3297-3-0085

Manufactured No

110

Each

3.0000

1



HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

3

70219

3

110

Each

3.0000

1

D3297-3-0210

Manufactured No



HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

3

70220

3

110

Each

3.0000

1

D4054-001

Manufactured No



Tube Assembly

Location

Loc Qty

Loc Code

ST193

3

58155

3

110

Each

3.0000

1

D4054-003

Manufactured No



Tube Assembly

Location

Loc Qty

Loc Code

ST193

3

58156

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Thursday, August 25, 2011 1:34:11 PM

Page 3

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

D3298-005

Manufactured No

110

Each

7.0000

1



Tube Assembly

Location

Loc Qty

Loc Code

ST195

7

47505

3

48509

1

55527

3

D3298-007

Manufactured No

110

Each

3.0000

1



Tube Assembly

Location

Loc Qty

Loc Code

ST195

3

58969

3

D4054-009

Manufactured No

110

Each

0.0000

1



Tube Assembly

D3299-7

Manufactured No

110

Each

3.0000

1



Fitting

Location

Loc Qty

Loc Code

ST047

3

57411

3

D3299-3

Manufactured No

110

Each

9.0000

1



Fitting

Location

Loc Qty

Loc Code

ST046

9

42171

3

55530

6

Thursday, August 25, 2011 1:34:11 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Thursday, August 25, 2011 1:34:11 PM

Page 4

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

D3299-5

Manufactured No

110

Each

10.0000

1

3



Fitting

Location

Loc Qty

Loc Code

ST047

10

43657

4

55531

6

D3301-1

Manufactured No

110

Each

6.0000

1

3



Placard

Location

Loc Qty

Loc Code

ST047

6

56685

6

D3301-3

Manufactured No

110

Each

4.0000

1

3



Placard

Location

Loc Qty

Loc Code

ST047

4

60250

4

D3302-1

Manufactured No

110

Each

7.0000

1

3



Doubler

Location

Loc Qty

Loc Code

ST143

7

70615

7

D3302-3

Manufactured No

110

Each

5.0000

1

3



Doubler

Location

Loc Qty

Loc Code

ST143

5

70616

5

Thursday, August 25, 2011 1:34:11 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Thursday, August 25, 2011 1:34:11 PM

Page 5

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

D3329-1.
Bushing

Manufactured No

110 Each

8.0000 2

Location

Loc Qty

Loc Code

ST048

8

70257

8

Purchased No

110 Each

1,029.000 4

AN3-5A
Bolt

Location

Loc Qty

Loc Code

ST350

1029

115371

46

117423

683

118626

300

Purchased No

110 Each

5.0000 1

AN814-8D
Plug

Location

Loc Qty

Loc Code

ST329

5

117967

5

Purchased No

110 Each

21.0000 2

AN815-6D
Union-M-Flare

Location

Loc Qty

Loc Code

ST294

2

118503

2

ST329

19

118090

16

118368

3

Thursday, August 25, 2011 1:34:12 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Thursday, August 25, 2011 1:34:12 PM

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

AN815-8D
Union-M-Flare

Purchased

No

110

Each

5.0000

1

Location

Loc Qty

Loc Code

ST329

5

114544

5

110

Each

24.0000

1

AN832-6D
UNION

Purchased

No

Location

Loc Qty

Loc Code

ST333

24

117909

8

118503

16

110

Each

5.0000

1

AN833-6D
Elbow, Bulkhead-M-Flare

Purchased

No

Location

Loc Qty

Loc Code

ST333

5

118006

5

110

Each

7.0000

1

AN833-8D
ELBOW

Purchased

No

Location

Loc Qty

Loc Code

ST333

7

114544

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, August 25, 2011 1:34:12 PM

Page 7

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

AN924-6D Purchased No 110 Each 28.0000



Nut



Location Loc Qty Loc Code

ST335

28

118422

8

118502

20

AN924-8D Purchased No 110 Each 5.0000



NUT



Location Loc Qty Loc Code

MEZZ

5

114544

5

AN938-6D Purchased No 110 Each 8.0000



Tee



Location Loc Qty Loc Code

ST336

8

101925

8

AN960JD10L NAS1149D0332J Purchased No 110 Each 0.0000



Washer



AN960JD10 NAS1149D0363J Purchased No 110 Each 0.0000



Washer



AN960JD916 NAS1149D0963J Purchased No 110 Each 0.0000



WASHER



4

1

3

12

24

76

M117087

M118077

M116683 11/8/30 SP (30)

Thursday, August 25, 2011 1:34:12 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, August 25, 2011 1:34:12 PM

Page 8

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

110

Each

1,789.000

4

12



Nut

Location

Loc Qty

Loc Code

ST300

1789

117441

150

117601

400

117885

239

118451

1000

MS21919-WDG9

Purchased

No

110

Each

298.0000

2

6



Clamp

Location

Loc Qty

Loc Code

ST307

98

118354

29

118406

69

ST309

200

118455

200

MS21920-42

Purchased

No

110

Each

0.0000

2

6



CLAMP(per MIL-DTL-8783C)

MS29512-06

Purchased

No

110

Each

26.0000

7

21



O-RING

Location

Loc Qty

Loc Code

ST294

26

118543

26

Thursday, August 25, 2011 1:34:12 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 1:34:12 PM

Page 9

Work Order ID: 73082

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister



Start Date: 8/25/2011

Required Date: 9/9/2011

Start Qty: 3.00

Required Qty: 3.00

MS29512-08

Purchased

No

110

Each

17.0000

3



O-RING



9

Location

Loc Qty

Loc Code

ST294

17

113706

1

117962

16

MS35489-16

Purchased

No

110

Each

25.0000

1



GROMMET



9
3
11/8/30 S (30)

Location

Loc Qty

Loc Code

ST295

25

118006

25

3

Thursday, August 25, 2011 1:34:12 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54

REF FAA STC: SR02055NY

REF. EASA STC: EASA.IM.R.S.01180

DESCRIPTION:

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

IS

QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING

Continue on next sheet

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.06.06
CERT. NO.: SH04-54
ISSUE NO.: 1

B	SHEET 2: D412-706-011 KIT: QTY(7) MS29512-06 WAS QTY(8), QTY(3) MS29512-08 WAS QTY(2), MS35489-16 WAS MS35489-11; DSI 9494-011 KIT P/L: ADDED AN814-8D PLUG AND MS35489-16 GROMMET, QTY(3) MS29512-08 O-RING WAS QTY(2). SHEET 3: AN814-8D PLUG WAS AN814-6D PLUG AND MS29512-08 WAS MS29512-06. REASON: NCR11-641.		MB	11.06.03
A	NEW ISSUE		RF	10.01.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	R	HAWKESBURY, ONTARIO, CANADA		
CHECKED	IP	DRAWING NO.	REV. B	
MFG. APPR.	N/A	DSI 9494	SHEET 1 OF 3	
APPROVED	CH	TITLE	SCALE	
DE APPR.	CH	212/412 CANISTER UPGRADE KIT	NTS	
DATE	11.06.03		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

REFERENCE ONLY S

Continue from previous sheet


B	4	AN3-5A	BOLT
	1	AN814-8D	PLUG
	2	AN815-6D	UNION
	1	AN815-8D	UNION (WAS AN815-6D)
	1	AN832-6D	UNION
	1	AN833-6D	ELBOW
	1	AN833-8D	ELBOW (WAS AN833-6D)
	4	AN924-6D	NUT
	1	AN924-8D	NUT (WAS AN924-6D)
	1	AN938-6D	TEE
	4	AN960JD10L	WASHER (OR NAS1149D0332J)
	8	AN960JD10	WASHER (OR NAS1149D0363J)
	2	AN960JD916	WASHER
	4	MS21042L3	NUT
	2	MS21919WDG9	CLAMP
	2	MS21920-42	CLAMP
B	7	MS29512-06	O-RING (WAS MS28778-6)
	3	MS29512-08	O-RING (WAS MS28778-8)
	1	MS35489-16	GROMMET





FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
B	1	AN814-8D
	1	AN815-8D
	1	AN833-8D
	1	AN924-8D
B	3	MS29512-08
	1	MS35489-16

WEIGHT AND BALANCE:
NO CHANGE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 11.06.06
CERT. NO.: SH04-54
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.	UAS	DSI 9494	SHEET 2 OF 3
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REFERENCE ONLY

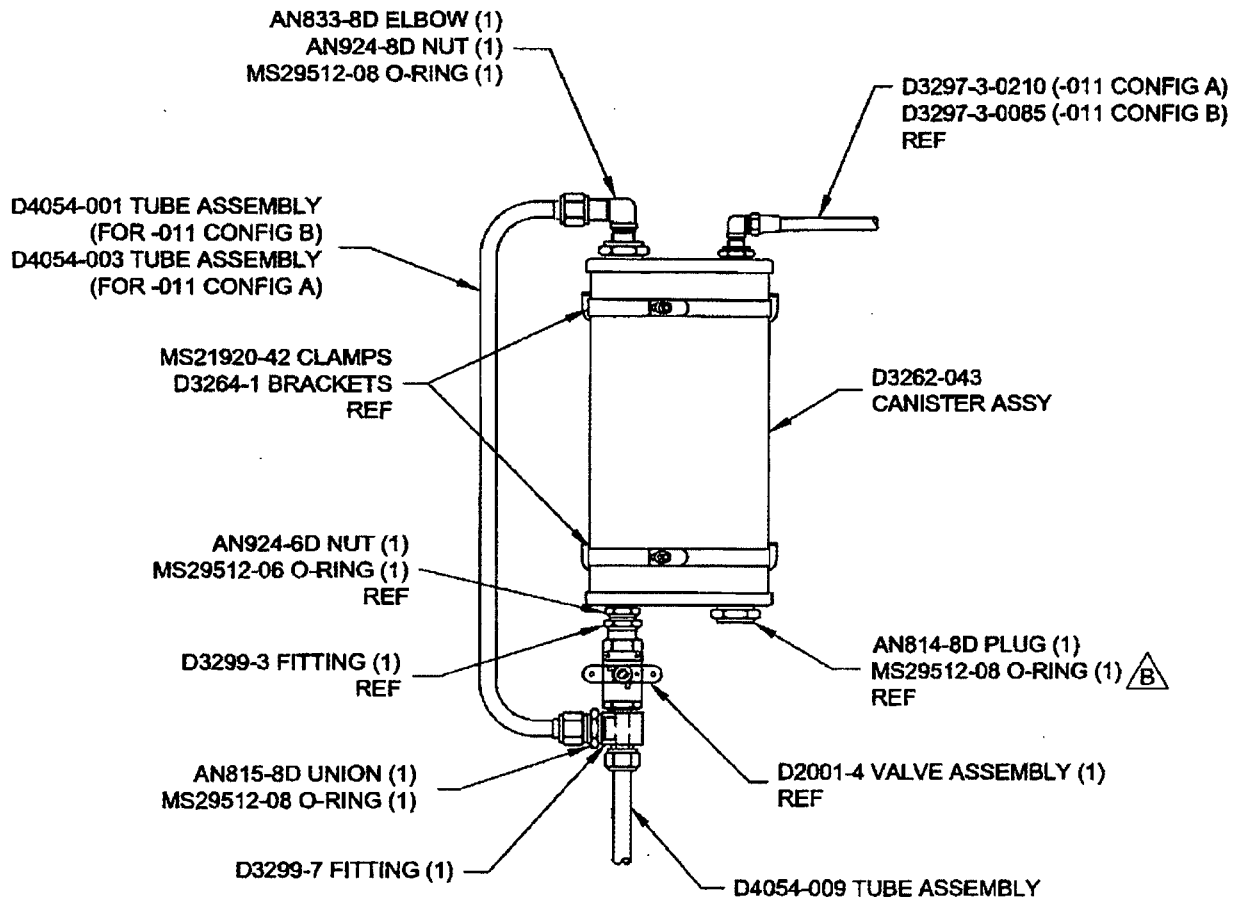







FIGURE 1. CANISTER ASSEMBLY
(-011 INSTALLATION AT CHG 002)

$\triangle B$ NOTE: FOR THE LARGER D4054-009 LINE, CUSTOMER MUST DRILL A $\phi 0.813$ HOLE AND INSTALL MS35489-16 GROMMET INSTEAD OF MS35489-11 GROMMET IN BELLY SKIN.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
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